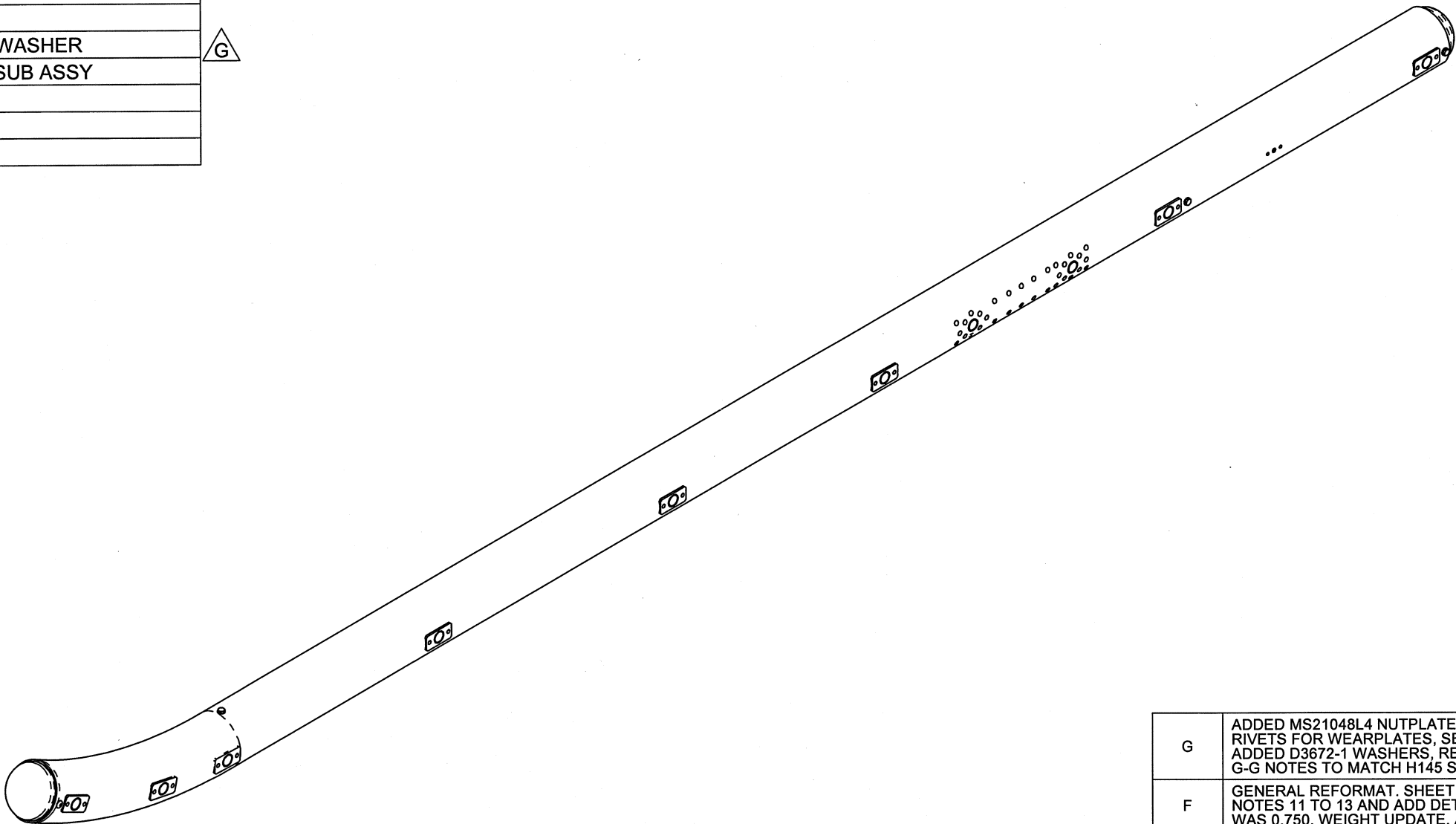


QTY -041	P/N	DESCRIPTION
X	D4680-041	SKIDTUBE
1	D2965	CAP
1	D2965-3	CAP
2	D3672-1	PHENOLIC WASHER
1	D4680-043	SKIDTUBE SUB ASSY
2	AN3C5A	BOLT
2	AN526C1032R10	SCREW
2	NAS1149C0332R	WASHER

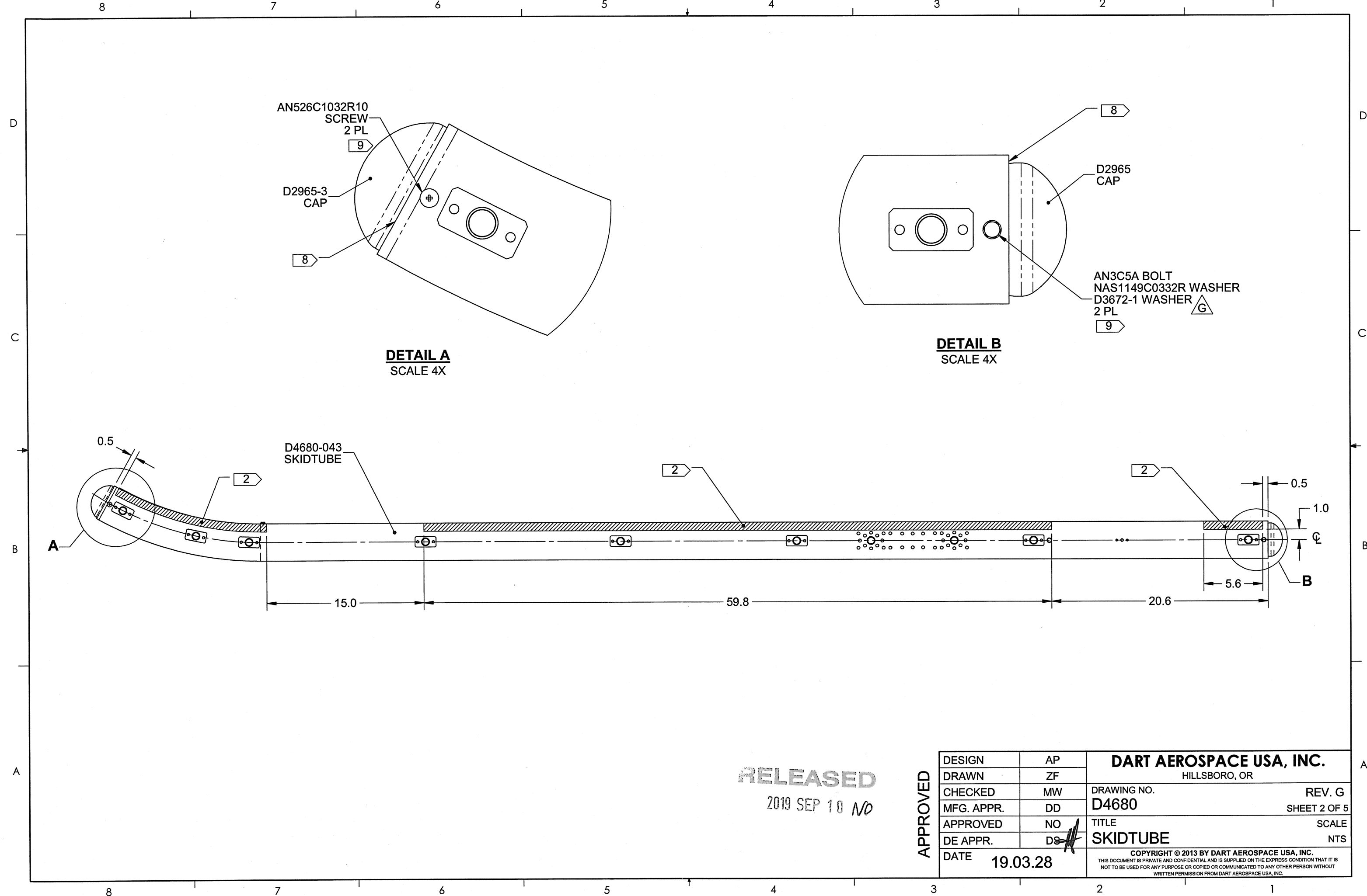


- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 1.00 ABOVE CENTERLINE PER QSI 005 SECTION 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4680-041" AND B/N PER QSI 044 METHOD 6.4 ON INNER RADIUS OF SKIDTUBE BEFORE INSTALLING D2965 CAP
 - 7) WEIGHT: 19.7 lbs
 - 8) SEAL FAYING SURFACES WITH SIKAFLEX -241/-291 OR PROSEAL 890/1422 OR MIL-S-8802 CLASS B-2 SEALANT
 - 9) INSTALL FASTENERS WET WITH SIKAFLEX -241/-291 OR PROSEAL 890/1422 OR MIL-S-8802 CLASS B-2 SEALANT

G	ADDED MS21048L4 NUTPLATES AND CR1122-3-02.5 RIVETS FOR WEARPLATES, SEE DETAIL L AND DETAIL M, ADDED D3672-1 WASHERS, REVISED SECTION C-C AND G-G NOTES TO MATCH H145 SKIDTUBES	ZF	19.03.28
F	GENERAL REFORMAT. SHEET 3: ADD ITEMS 6 & 11 ADD NOTES 11 TO 13 AND ADD DETAIL H. SHEET 5: Ø0.188 WAS 0.750. WEIGHT UPDATE. ADD PROSEAL 1422	AJS	17.03.30
E	GROUND HANDLING CROSSBOLT SPACERS NOW SWAGED, WAS WELDED. REMOVED D3492-055 PLUG ASSEMBLIES	AP	15.11.02
D	MOVED AFT GROUNDING FASTENER HOLE AFT 0.25 DUE TO INTERFERENCE, ADDED NOTE 9 (SHT 1), GROUNDING STRAP WASHERS NOW STAINLESS	AP	15.03.04
C	NAS1149F0332P WAS AN960-10L, AN526C1032R10 WAS AN526C1032-10, FWD GROUNDING STRAP FASTENER MOVED AFT (C5-3), Ø0.750 WAS Ø0.758 (B4-3).	AP	14.07.29
B	FWD CAP WAS D2965 NOW D2965-3, VARIOUS DIMENSIONAL CHANGES. D3492-055 PLUG ASSY WAS D3492-051, SWAGING DIMENSION NOW 0.650 WAS 0.661 (D6-2), ADDED DETAIL H (C2-3), MATERIAL D2962-150 WAS D2962-131 (A7-3), GROUND HANDLING THRU HOLES NOW WELDED, ADDED SECTION G-G (D3-2)	AP	13.09.10
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
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CHECKED	MW	DRAWING NO.	REV. G
MFG. APPR.	DD	D4680	SHEET 1 OF 5
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	SKIDTUBE	NTS
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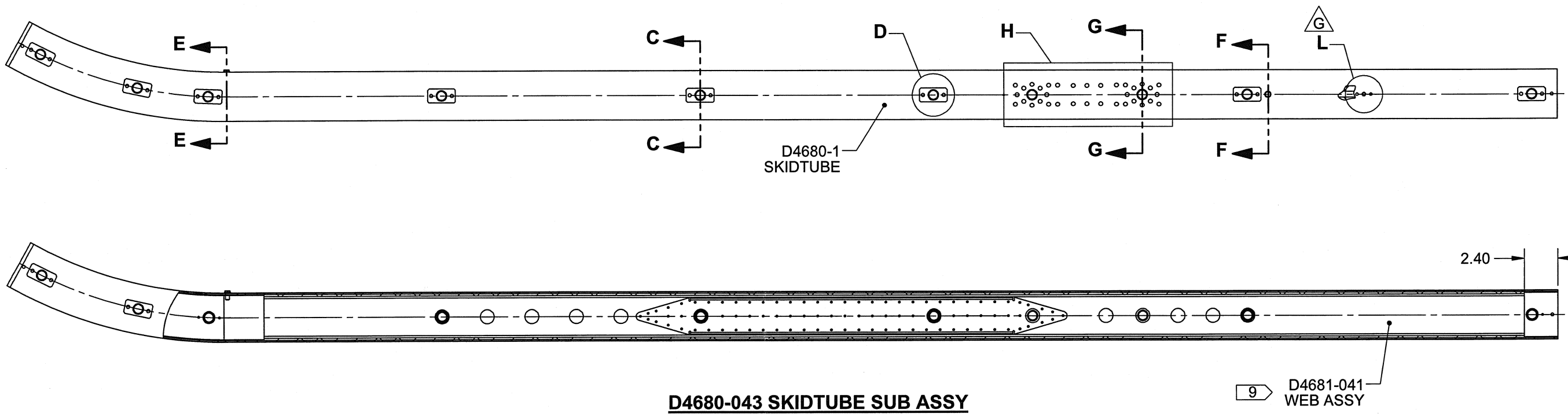
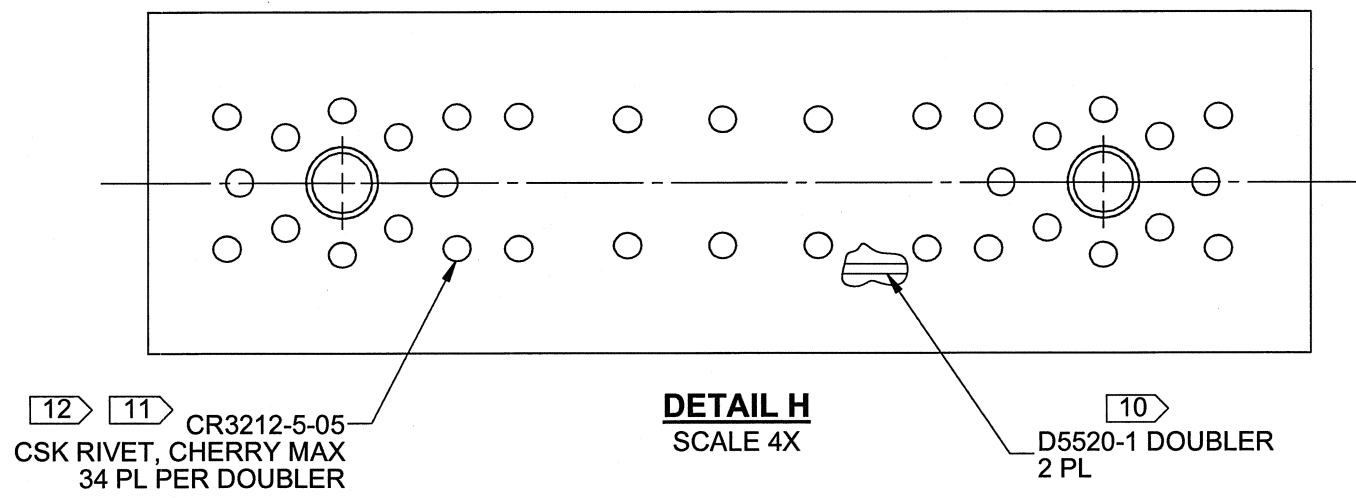
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QTY -043	P/N	DESCRIPTION
X	D4680-043	SKIDTUBE SUB ASSY
1	D4680-1	SKIDTUBE
1	D4681-041	WEB ASSY
8	D4686-1	SPACER
16	D4753-1	DOUBLER
2	D5304-1	CROSSBOLT SPACER
2	D5520-1	DOUBLER
3	AELS-1032-130	INSERT
3	AN3C4A	BOLT
4	CR1122-3-02.5	RIVET
68	CR3212-5-05	CSK RIVET, CHERRY MAX
32	MS20601AD4W3	RIVET, BLIND, CSK
2	MS21048L4	NUTPLATE
3	NAS1149C0332R	WASHER

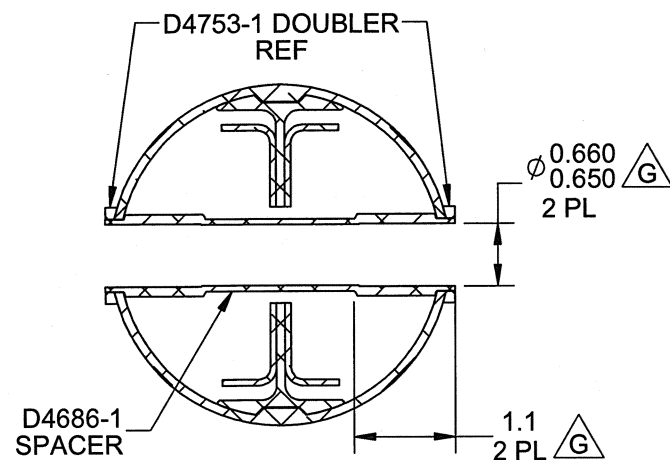


- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: APPLY CHEMICAL CONVERSION COATING PER DART QSI 005 4.1 PRIOR TO INSTALLING D4681-041 WEB. POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 18.9 lbs
 - 8) SEAL ALL MATING SURFACES USING PROSEAL 890/1422 OR MIL-S-8802 CLASS B2 SEALANT
 - 9) INSERT D4681-041 WEB INTO D4680-1 SKIDTUBE IN LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX -241/-291 ADHESIVE PER DART QSI 015
 - 10) LOCATE THE D5520-1 DOUBLER USING THE $\phi 0.188$ PILOT HOLES ON THE SKIDTUBE AND DOUBLER
 - 11) LOCATE QTY (34) HOLES ONTO THE SKIDTUBE PER D5520-1 DOUBLER AND DRILL $\phi 0.161$ THRU SKIDTUBE AND DOUBLER USING DT10309
 - 12) COUNTERSINK THE SKIDTUBE $\phi 0.286 \times 100^\circ$ (34 PL) AND INSTALL EACH D5520-1 DOUBLER USING QTY (34) CR3212-5-05 CSK RIVETS

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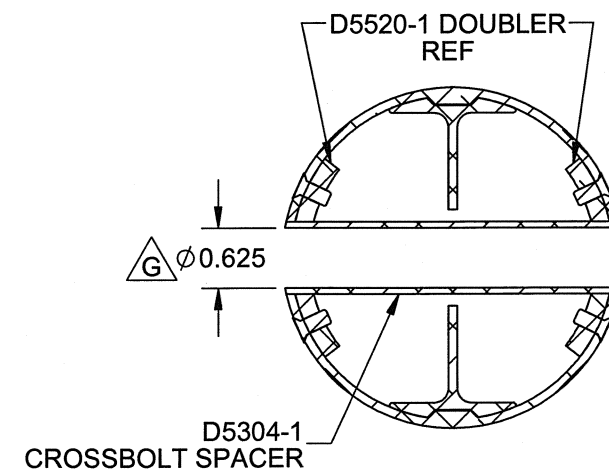
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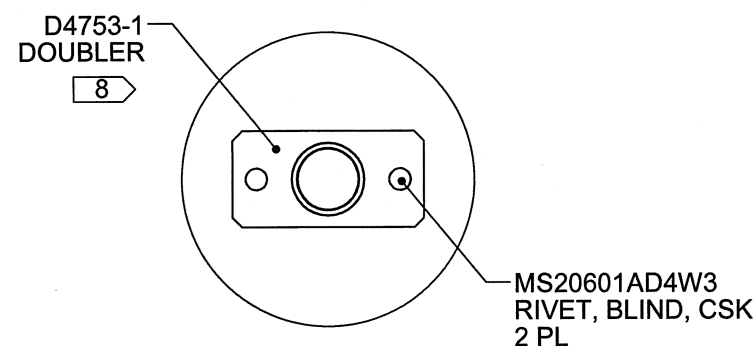
SECTION C-C
SCALE 4X
8 PL

- INSTALL D4686-1 SPACER AFTER INSTALLING D4753-1 DOUBLERS AS FOLLOWS:
1. REAM $\phi 0.758$ THRU DOUBLERS AND SKIDTUBE.
 2. INSERT D4686-1 SPACER
 3. SWAGE TO $\phi 0.660 / 0.650 \times 1.0$ DP EACH SIDE PER DART QSI 002
 4. TRIM/GRIND SPACER FLUSH WITH DOUBLER PER QSI 002

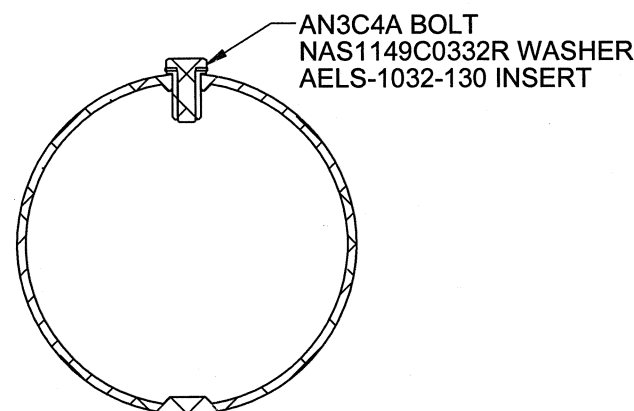


SECTION G-G
SCALE 4X
2 PL

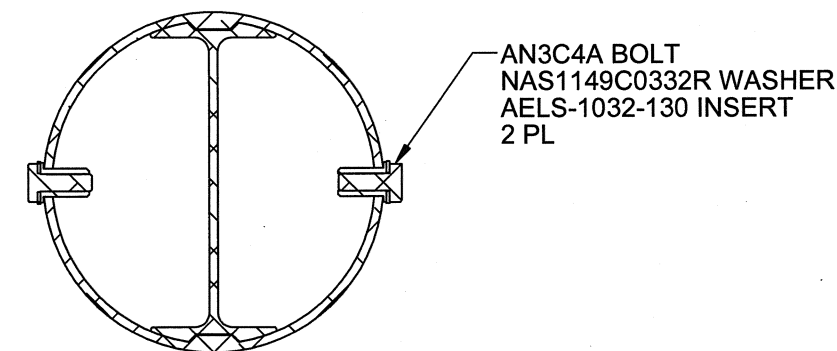
- INSTALL D5304-1 CROSSBOLT SPACER AFTER INSTALLING D5520-1 DOUBLERS AS FOLLOWS:
1. OPEN PILOT HOLES THRU SKIDTUBE AND DOUBLERS TO $\phi 0.758$
 2. INSERT D5304-1 CROSSBOLT SPACER
 3. SWAGE TO $\phi 0.570 / 0.565 \times 1.0$ DP EACH SIDE PER DART QSI 002
 4. OPEN HOLE THRU SPACER TO $\phi 0.625$



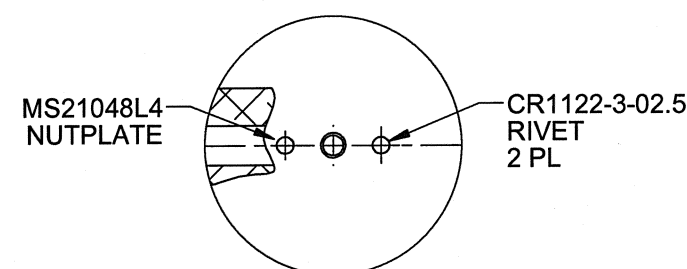
DETAIL D
16 PL (BOTH SIDES)
SCALE 4X



SECTION E-E
SCALE 4X



SECTION F-F
SCALE 4X



DETAIL L
SCALE 4X
BOTH SIDES

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